

Work Order ID 76286

76286

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Tuesday, November 08, 2011 1:33:05 PM

Item ID: D3911-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Eyebolt Receiver Assembly
 Start Date: 11/8/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3911	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3911-5 to D3911-3 and install rivet as per dwg Trim rivet to 1.250" Full Lengh								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

EB 11/12/06 (2)

EB 11/12/06 (2)

5 11/12/06

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>507</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/12/11
mk
11-12-06

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NOTE: Date & initial all entries

Picklist Print

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Tuesday, November 08, 2011 1:33:11 PM

Work Order ID: 76286

76286

Parent Item: D3911-043

D3911-043

Parent Item Name: Aft Eyebolt Receiver Assembly

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV :C As per

Rev C 10-04-07 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3911-3		Manufactured	No			100	Each	0.0000	1	2			
D3911-3						B71151		(24)	**			11/12/06	
Aft Eyebolt Receiver													
D3911-7		Manufactured	No			100	Each	1.0000	2				
D3911-7									**			11/12/06	
Basket Plate-Eyebolt Receiver													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST091		1							
				68986		1							
MS20615-4M20		Purchased	No			100	Each	114.0000	4	8			
MS20615-4M20									**			11/12/06	
RIVET													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		114							
				117071		30							
				118571		34							
				119546		50							

B76290 (30)

11/12/06

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

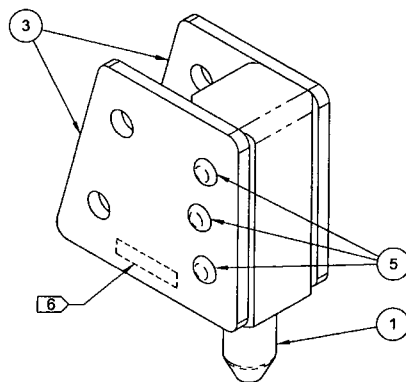
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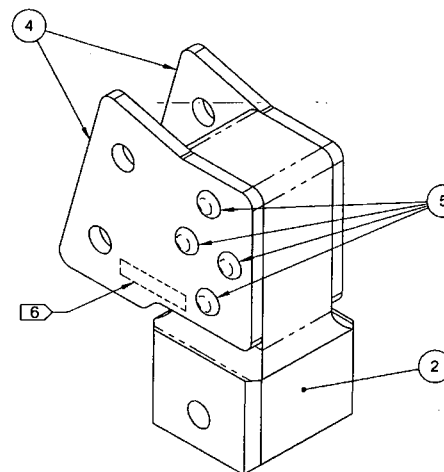
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76286
M.L.C.
11/11/08

RELEASED
2010-08-06

D	0.825 +0.000/-0.010 WAS 0.65 (B1-2).	MB	10.06.22
C	BOM: QTY (2). D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3911	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	AFT HARDPOINT, BASKET	NTS
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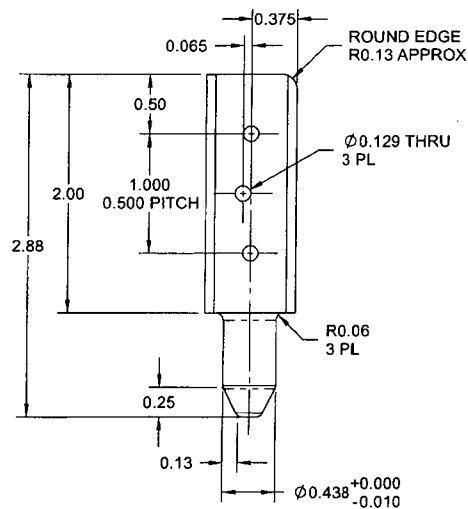
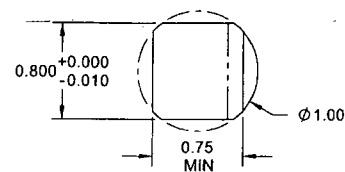
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8 7 6 5 4 3 2



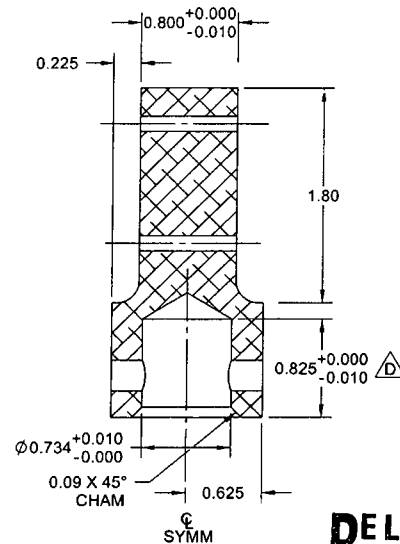
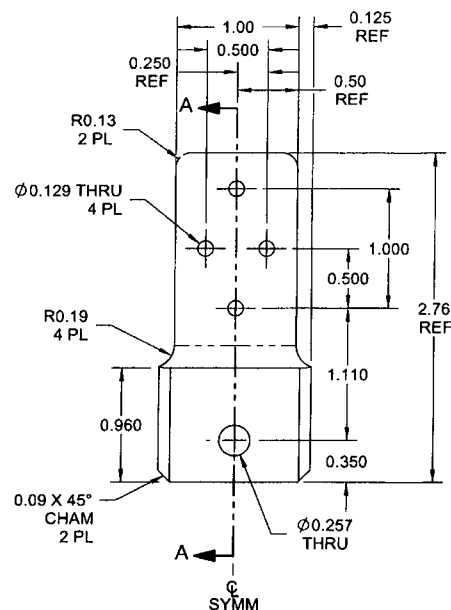
0.09 X 45°
CHAMFER

1.250

1.250

0.625
REF

C
SYMM



DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. I
MFG. APPR.	<i>[Signature]</i>	D3911	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR: --	<i>[Signature]</i>	AFT HARDPOINT, BASKET	
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2010-08-04
MD

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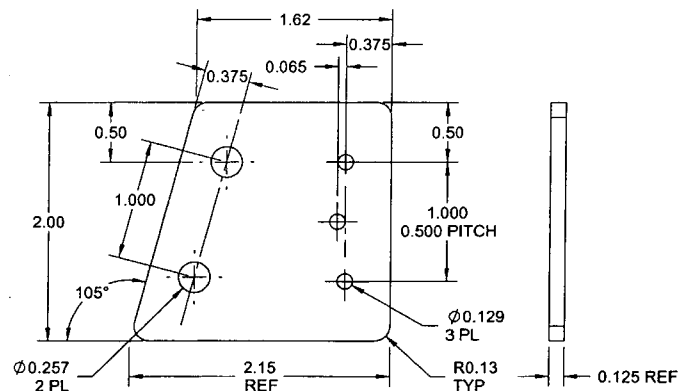
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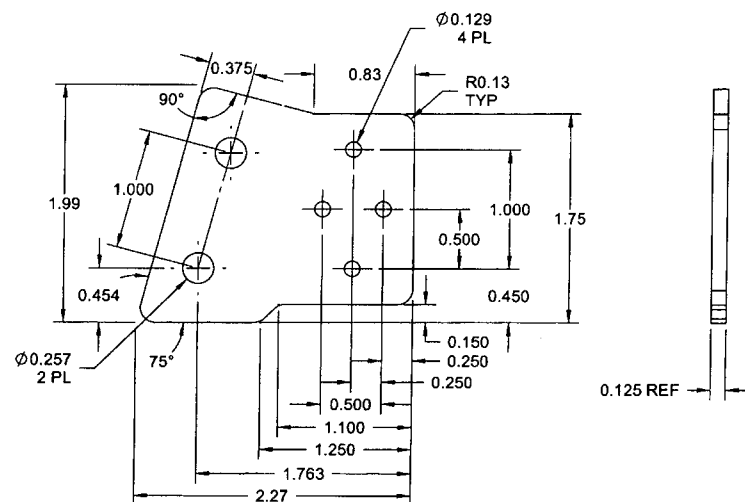
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76280



D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT--5: 0.13 lbs
-7: 0.13 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3911	REV. D
MFG. APPR.		TITLE AFT HARDPOINT, BASKET	SCALE NTS
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DATE	10.06.22		

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2010-08-06
NWS

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